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PTO/SB/05 (4/98)
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Patent and Trademark Office: U.S. DEPARTMENT OF COMMERCE

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UTILITY PATENT APPLICATION TRANSMITTAL <small>(Only for new nonprovisional applications under 37 C.F.R. § 1.53(b))</small>	Attorney Docket No. MRA-PT001
	First Inventor or Application Identifier Burton J. Price
	Title METHOD FOR MANUFACTURING A SOUND INSULATING STRUCTURE AND THE STRUCTURE PRODUCED THEREBY
	Express Mail Label No. EL216101546US

APPLICATION ELEMENTS <small>See MPEP chapter 600 concerning utility patent application contents.</small>	ADDRESS TO: Assistant Commissioner for Patents Box Patent Application Washington, DC 20231	
1. <input checked="" type="checkbox"/> * Fee Transmittal Form (e.g., PTO/SB/17) (Submit an original and a duplicate for fee processing)	5. <input type="checkbox"/> Microfiche Computer Program (Appendix)	
2. <input checked="" type="checkbox"/> Specification [Total Pages 15] (preferred arrangement set forth below) <ul style="list-style-type: none">- Descriptive title of the Invention- Cross References to Related Applications- Statement Regarding Fed sponsored R & D- Reference to Microfiche Appendix- Background of the Invention- Brief Summary of the Invention- Brief Description of the Drawings (if filed)- Detailed Description- Claim(s)- Abstract of the Disclosure	6. Nucleotide and/or Amino Acid Sequence Submission (if applicable, all necessary) <ul style="list-style-type: none">a. <input type="checkbox"/> Computer Readable Copyb. <input type="checkbox"/> Paper Copy (identical to computer copy)c. <input type="checkbox"/> Statement verifying identity of above copies	
3. <input checked="" type="checkbox"/> Drawing(s) (35 U.S.C. 113) [Total Sheets 4]	ACCOMPANYING APPLICATION PARTS 7. <input type="checkbox"/> Assignment Papers (cover sheet & document(s)) 8. <input type="checkbox"/> 37 C.F.R. § 3.73(b) Statement <input type="checkbox"/> Power of Attorney (when there is an assignee) 9. <input type="checkbox"/> English Translation Document (if applicable) 10. <input type="checkbox"/> Information Disclosure Statement (IDS)/PTO-1449 <input type="checkbox"/> Copies of IDS Citations 11. <input type="checkbox"/> Preliminary Amendment 12. <input checked="" type="checkbox"/> Return Receipt Postcard (MPEP 503) (Should be specifically itemized) 13. <input type="checkbox"/> * Small Entity Statement(s) <input type="checkbox"/> Statement filed in prior application, Status still proper and desired (PTO/SB/09-12) 14. <input type="checkbox"/> Certified Copy of Priority Document(s) (if foreign priority is claimed) 15. <input checked="" type="checkbox"/> Other: Communication Under Rule 37 C.F.R. 153(b); A check in the amount of \$994; Certificate of Mailing By Express Mail.	
4. Oath or Declaration (unsigned) [Total Pages 3] <ul style="list-style-type: none">a. <input type="checkbox"/> Newly executed (original or copy)b. <input type="checkbox"/> Copy from a prior application (37 C.F.R. § 1.63(d)) (for continuation/divisional with Box 16 completed)<ul style="list-style-type: none">i. <input type="checkbox"/> DELETION OF INVENTOR(S) Signed statement attached deleting inventor(s) named in the prior application, see 37 C.F.R. §§ 1.63(d)(2) and 1.33(b).		
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Signature		Date	3/10/99

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**METHOD FOR MANUFACTURING A SOUND INSULATING
STRUCTURE AND THE STRUCTURE PRODUCED THEREBY**

BACKGROUND OF INVENTION

Field of the Invention

5 The present invention generally relates to trim panels used to cover the interior surfaces of a vehicle. The invention more particularly relates to panels used to cover the interior surfaces of a passenger vehicle where sound attenuation is desired. The invention most particularly relates to panels which are used in passenger vehicles where appearance and sound attenuation are required. Such panels are employed as the head liners, wall liners and carpets of a vehicle for the purpose of improving appearance, temperature and sound control while enhancing the passengers' driving pleasure.

Description of the Prior Art

15 The use of trim panels and carpet panels to provide passenger comfort are well known in the art. For example, see U.S. Patents 4,741,945; 4,508,774; and 5,334,338. In addition, the use of these known manufacturing techniques employed by the present invention for producing standard floor covering is also known. See U.S. Patent 5,855,981.

 Early efforts at sound attenuation in vehicles generally relied upon heavy, dense materials which would resist the entry of exterior noises into the passenger cabin. However,

experience with such materials led to concerns about the transmission of vehicle vibrations and other sounds based upon the heavy insulating materials. Accordingly, the art has recently considered the use of ultralight, multifunctional, sound-insulating materials. For example, see WO 98/18656 and WO 98/18657.

5 More recently, it has been determined that ultralight, multifunctional, sound-insulating materials may not achieve their full benefit when used with exterior cover materials that do not compliment their function. Accordingly, the art desired an exterior or decorative cover material which permitted controlled sound transmission to the interior of the vehicle. It has been theorized that permitting transmission of some sound into the cabin will result in sound cancellation and a more pleasing passenger environment. As a result of the more pleasing environment, the use of ultralight materials will be greatly enhanced and a reduction in vehicle weight will be recognized without any decrease in cabin comfort.

SUMMARY OF THE INVENTION

15 The present invention provides a sound insulating structure cover panel that compliments the sound attenuation material. The method of manufacturing the panel comprises the steps of providing a laminated blank having an interior face which will be observable from the passenger compartment. The side opposite the interior face of the blank has a generally non-permeable polymeric layer adjacent to a primary backing and a

secondary backing layer overlying the polymeric layer. In the preferred process, the previously described blank is elevated to a desired temperature and positioned in a closed forming mold such that the perimeter of the blank is retained in a fixed position. The forming mold is closed with a controlled pressure that is sufficient to expand the blank, conform it to the mold and render a panel having a desired permeable. Preferably, the post formation panel has a permeability of 500 rayls or less as measured on concentric airflow resistance equipment (C.A.R.E. unit) available from Rieter Automotive North America, Inc. 38555 Hills Tech Drive, Farmington Hills, MI 48331.

BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 illustrates a known carpet construction which is suitable for use with the present invention.

Figure 2 is an enlargement of the construction within the phantom lines of **Figure 1**.

Figure 3 is an enlargement, similar to **Figure 2**, showing the wicking-in of the polymeric layer in the construction of the present invention as described in the exemplary embodiment of **Figure 1**.

Figure 4 illustrates the wicking-in of **Figure 3** within the tufts of yarn.

Figure 5 illustrates a continuous operation for stretching and molding a panel in accordance with the present invention.

Figure 6 illustrates a heating table for use with a preferred manufacturing process.

Figure 7 illustrates a mold assembly in accordance with the invention.

5 **Figure 8** illustrates a panel in the final molding and cooling stage.

Figure 9 illustrates a molded and cooled panel prior to trimming.

DETAILED DESCRIPTION OF THE INVENTION

The invention will be described with reference to the drawing figures wherein like numbers indicate like elements throughout. It will be appreciated by those skilled in the art that the drawing figures are not to scale and liberties have been taken to permit illustration of the invention.

With reference to **Figure 1**, there is shown a material blank **2** wherein a backing layer **10**, of woven or non-woven construction, is used as a support base for a plurality of yarn tufts **12**. Each of the yarn tufts **12** is comprised of a plurality of yarns in either a spun or filament construction. After the insertion of tufts **12** into the backing **10**, the tufted assembly may be subjected to color and finishing operations before an extrusion coating process which places a polymeric layer **14** on the underside thereof. Finally, a backing layer **16**, generally a porous, non-woven material, is applied to the polymeric layer **14**. This

construction will be known to those in the art. As a result of this construction, the resulting laminate will have a face surface **18** which will be the interior surface and a backing surface **20** which will be the exterior surface. For use in the automotive industry, the laminated material is cut into a blank that is subjected to a molding process for producing a post formation panel of a desired geometry in accordance with the vehicle body geometry. Such a construction is known to those skilled in the art and does not form any part of the present invention.

Although the above-described construction of the laminate and the panels are known to those skilled in the art, the present invention differs from the known constructions in the selection of materials for polymeric layer **14** and the post formation process parameters used to form the panels. In keeping with the present invention, the polymeric layer **14** is comprised of a high melt flow polymer which will provide the desired response to the subsequent processing in accordance with the invention. Test materials and panels used to demonstrate the present invention are described below.

The tufted assemblies used for testing were produced by tufting continuous filament yarns of 1400 denier or 1405 denier BCF nylon yarns into non-woven primary backing substrates of 120 g/m²-140g/m² polyester fiber. If desired, spun or other yarn constructions may be used. Tufting machine gauges of 1/8 gauge and 1/10 gauge have been evaluated. It will be recognized by those skilled in the art that machine gauge stitches per inch and

stitch pile height combine to determine the overall carpet construction and density. The number of penetrations per square inch is a factor in determining the available porosity and the wicking-in ability of the construction. The available porosity is an important aspect of the invention because the final product of the preferred embodiment must meet the aesthetic and durability standards set by the vehicle manufacturer. As the construction is altered, the percentage of expansion to achieve the desired post formation product may need to be modified.

The tufted assemblies of the tests were extrusion coated, using known techniques, with a low density polyethylene coating **14** and laminated with a light weight secondary non-woven polyester substrate. A polyethylene coating **14**, of AT 193, available from A. T. Plastic, Inc. of Ontario, Canada, applied between 375-400 g/m² has been used successfully with a known 13-17 g/m² secondary polyester substrate **16**.

The secondary substrate **16** is laminated directly to the polyethylene **14** using a standard nip roll, in accordance with prior practices. The temperature of the polyethylene extruding from the die is approximately 400°F. The nip pressure, for a laminate of approximately .250 inches, at the rolls was approximately 50 pounds per linear inch and the nip setting was approximately .030 inches. The chill roll temperature was in the range of 55-70°F, and the process line speed varied between 25-40 FPM. At this point, the laminated material was either rolled up or cut into blanks in preparation for the molding operation.

Although this laminated material is still non-permeable, it is correctly prepared for the subsequent process which will render it permeable.

In order to form a finished panel, a specific blank size was cut and heated prior to molding. Through reheating of the carpet laminate, the polymeric layer **14** begins wetting out or wicking-in, see **Figures 3 and 4**. This causes the polymeric layer 14 to flow into the primary backing **10** and the tufts **12**. This is the beginning of the transformation from a non-permeable to a permeable laminate. The transformation to the desired permeability was achieved by stretching, molding and curing the heated laminate.

Heating of the material **2** for 25-30 seconds under a heat intensity of 10 to 15 watts per square inch of material has been found to provide a satisfactory temperature elevation with the test material. By heating the back surface **20** to a temperature between 325°-350°F, the polymeric layer **14** can be worked without causing melt flow or a loss of adhesion. The heated blank was molded in a chilled molding tool at approximately 1.5 to 4.0 PSI of mold pressure and 45°F. The approximate cool down time in the molding tool was forty-five (45) seconds. In the test material, these conditions produced a controlled stretch of seven to ten percent (7-10%) of the blank size. Upon removal from the mold, a face panel with the desired air permeability had been produced.

With reference to **Figures 5 through 9**, the manufacturing process, as used to produce test samples and as envisioned for production quantities, will be described. As illustrated

in **Figure 5**, the material moves from a supply roll to a heating table (**Figure 6**) through a mold (**Figures 7 and 8**) and is off loaded or further processed as a panel (**Figure 9**).

In **Figures 5 and 6**, a supply roll **40** of laminated blank material **2** is secured to a tenter frame **46** which has material retaining means **48** spaced in accordance with the desired blank perimeter. The retainer means **48** may be pins, clips or other holding means to grip the material and establish the length and width of the blank. They preferably are adjustable or removable to provide a cutting gap **50** where a transverse cutter **51** can cut the blank from the supply roll **40**. The blank passes over the heating table **52** beneath a plurality of heating elements **54** which are selected in accordance with the construction of the laminated blank material **2** so as to achieve the desired temperature. It is expected that the elements at the entrance **56** will be selected to rapidly elevate the temperature while the elements at the exit **58** will be selected to achieve equalization at a desired temperature.

In **Figure 7**, the heated panel **60** is presented to the refrigerated mold **62** which has a movable, pressure applying half **64** and a stationary refrigerated half **66**. While being held by the retainers **48**, the blank **60** is aligned over the mold as it is closed at the desired pressure to stretch the generally planar blank **60** over the contour of the mold. It will be recognized by those skilled in the art that the mold **62** is configured, in both halves **64** and **66**, to the geometry of the vehicles floor board. When the mold **62** is finally closed, as illustrated in **Figure 8**, the blank **60** might be repositioned in the mold **62**, however, the

original perimeter of the blank will remain substantially unchanged. After the molded panel 70 is released from the mold, **Figure 9**, it may continue to a subsequent processing operation as described hereinafter, or the perimeter may be trimmed to provide a finished and cut to size molded panel.

5 The test samples produced for this invention were made with the use of piece goods that were presented to the heating table and molded through a hand operation. In this operation, the heated blank was manually placed over a stationary tenter frame adjacent to the mold and the mold was manually emptied when the stretching and molding operation had been completed.

10 Permeability of the test samples was established by using a C.A.R.E. unit. On average, three readings were taken in four locations on each sample to establish that the panel had achieved the desired permeability. Generally, for automotive purposes, it is preferred to take the test reading in the flat of the foot wells or the base of the panel. In any event, it is preferred that the reading be taken in an area more representative of the mold extension. Thus, a flat portion directly over the tunnel may not be fairly representative. In 15 addition to the above, the use of a well base also provides the practical advantage of being accessible and supportable. It is important to support the sample on a firm but open surface, such as a mesh table, that will not restrict air flow, so the test equipment can be applied firmly.

As noted previously, this invention was motivated by the desire to enhance the use of ultralight material as described in W098/18656 and 2098/18657. The description of that material is incorporated herein as if fully set forth. In keeping with the effort to achieve the maximum benefits of this combination, the assembly of the panel 70 to the ultralight material will be described. Since the combined components must maintain the permeability of the entire sound insulation assembly within a specified range, they must be carefully adhered together. One acceptable adhesive is available from National Starch as item 34-3378 with a melt viscosity of 1500-2125 centapoise at an application temperature of approximately 400°F. An application of hot melt adhesive in the range of 7-9 gm/Ft.² has found to be successful in adhering the components while maintaining the desired permeability.

The adhesive which may be applied to either the carpet or the insulator, preferably, is in a randomized web. This randomized application assures adhesive bonding in all areas without restricting the permeability. The two components should be aligned for accuracy before bonding to prevent multiple positioning attempts which diminish the adhesion and disturb the permeability. The assembly press used to assure physical bonding of the components has preset stops which limit the forces on the components and prevents compression of the sound insulator beyond that needed for adhesion and maintains the assembly's permeability characteristics. Based on the test samples, the assembled

components should be compressed with a force that will not compress the ultralight material beyond its specified finished part thickness by more than 2mm. This avoids a compression from which the ultralight material may not rebound.

It will be recognized by those skilled in the art that the automotive industry has specifications and test methods for product performance and durability that must be met by the product in the field. The panels produced in accordance with the present invention have met these product and test specifications.

CLAIMS

I claim:

1. A process for manufacturing a sound insulating structure comprising the steps of:

providing a textile material having interior and exterior sides, a generally non-permeable polymeric layer overlying the exterior side and a backing layer overlying the polymeric layer to form a laminated product;

presenting the laminated product to a forming mold such that the perimeter of the product is retained in a fixed position relative to the mold; and

closing the forming mold under a controlled pressure, heat and time cycle sufficient for expanding the panel to conform it to the mold and to render the laminated product permeable.

2. A laminar assembly of a type having a textile material with interior and exterior surfaces, a non-permeable polymeric layer, overlying the exterior surface, and a backing layer, overlying the non-permeable layer, that are laminated together with the laminated product postformed in a molding apparatus, the improvement characterized by:

the polymeric layer having a post formation permeability of 500 rayls or less as measured by concentric airflow resistance equipment.

3. A vehicle sound insulating structure of a type having a carpet assembly with face and interior surfaces and a polymeric layer overlying the interior surface, and sound insulating material overlying the polymeric layer, the improvement characterized by:

the carpet assembly having a permeability of no more than 500 rayls as measured by concentric airflow resistance equipment.

4. A process for manufacturing a sound insulating structure comprising the steps of:

providing a textile panel having interior and exterior faces, a generally non-permeable polymeric layer overlying the exterior face and a backing layer overlying the polymeric layer;

preheating the panel to a controlled temperature;

positioning the preheated panel in a forming mold such that the perimeter of the panel is retained in a fixed position relative to the mold; and

closing the forming mold with controlled pressure sufficient for expanding the panel to conform it to the mold and to produce a desired permeability through the panel.

5. An assembly of a type having a panel with interior and exterior surfaces, a polymeric layer, overlying the exterior surface, and a backing layer, overlying the polymeric layer, laminated together with the laminate post formed in a molding apparatus, the improvement characterized by:

5 a post formation panel having a permeability of 500 rayls or less as measured by concentric airflow resistance equipment.

6. A vehicle carpet assembly with face and interior surfaces and sound insulating material adjacent the interior surface carpet assembly characterized by:

the carpet assembly having a permeability of 500 rayls or less as measured by concentric airflow resistance equipment.

ABSTRACT

The present invention provides a sound insulating structure cover panel that compliments the sound attenuation material. The method of manufacturing the panel comprises the steps of providing a laminated blank having an interior face which will be observable from the passenger compartment. The side opposite the interior face of the blank has a generally non-permeable polymeric layer adjacent to a primary backing and a secondary backing layer overlying the polymeric layer. In the preferred process, the previously described blank is elevated to a desired temperature and positioned in a closed forming mold such that the perimeter of the blank is retained in a fixed position. The forming mold is closed with a controlled pressure that is sufficient to expand the blank, conform it to the mold and render a panel having a desired permeable.

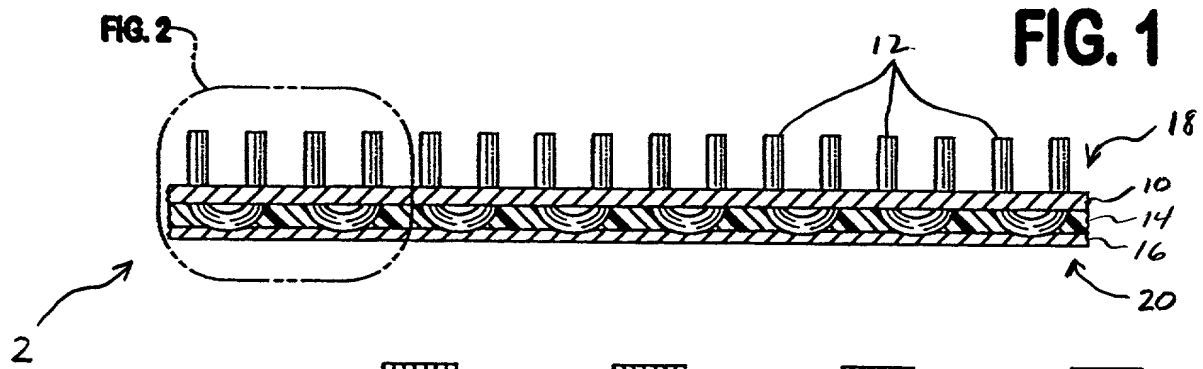


FIG. 2

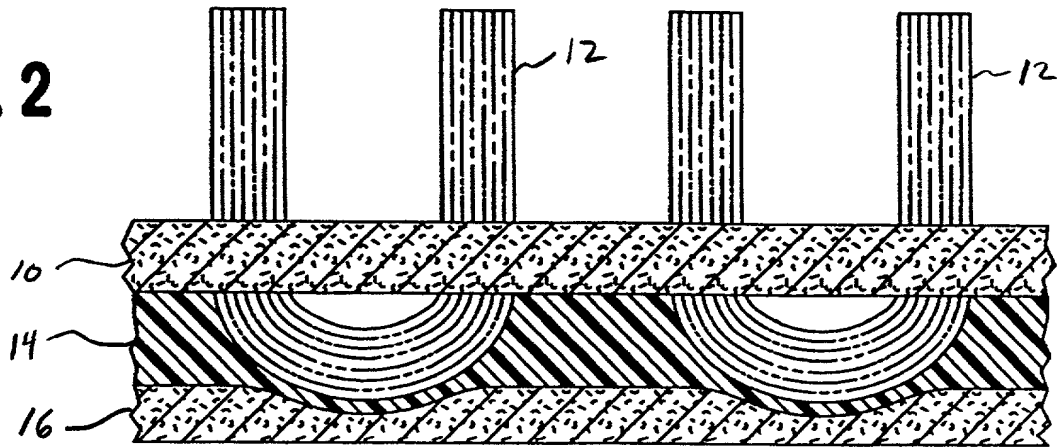


FIG. 3

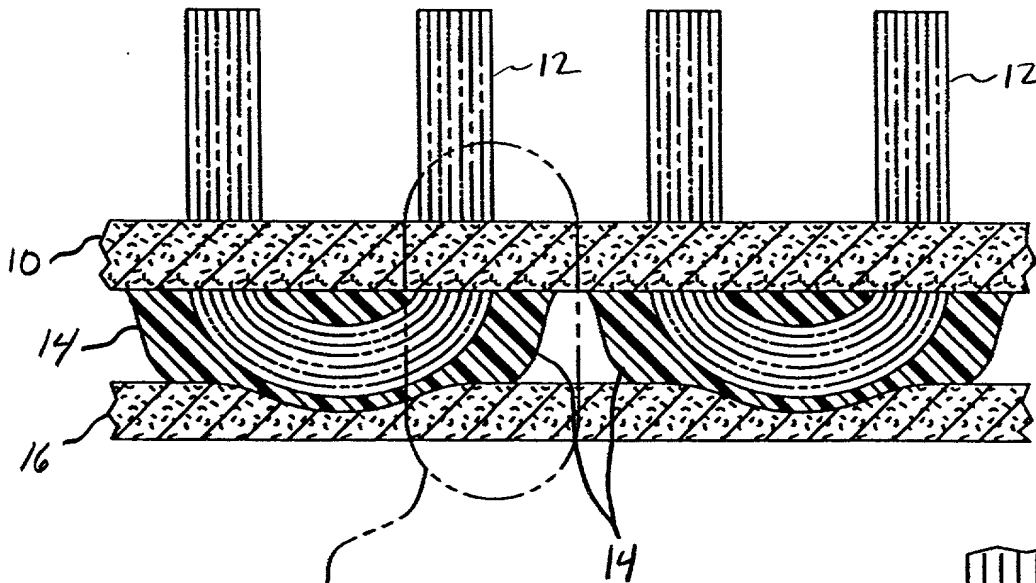


FIG. 4

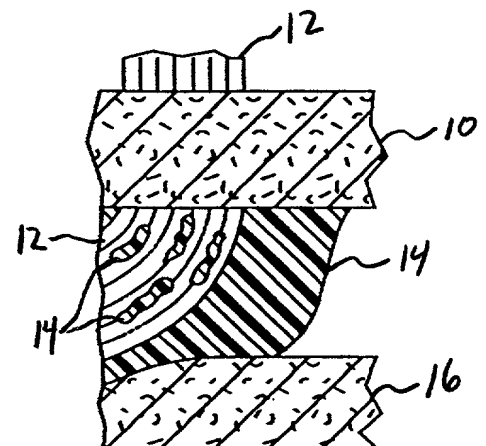


FIG. 4

FIG. 5

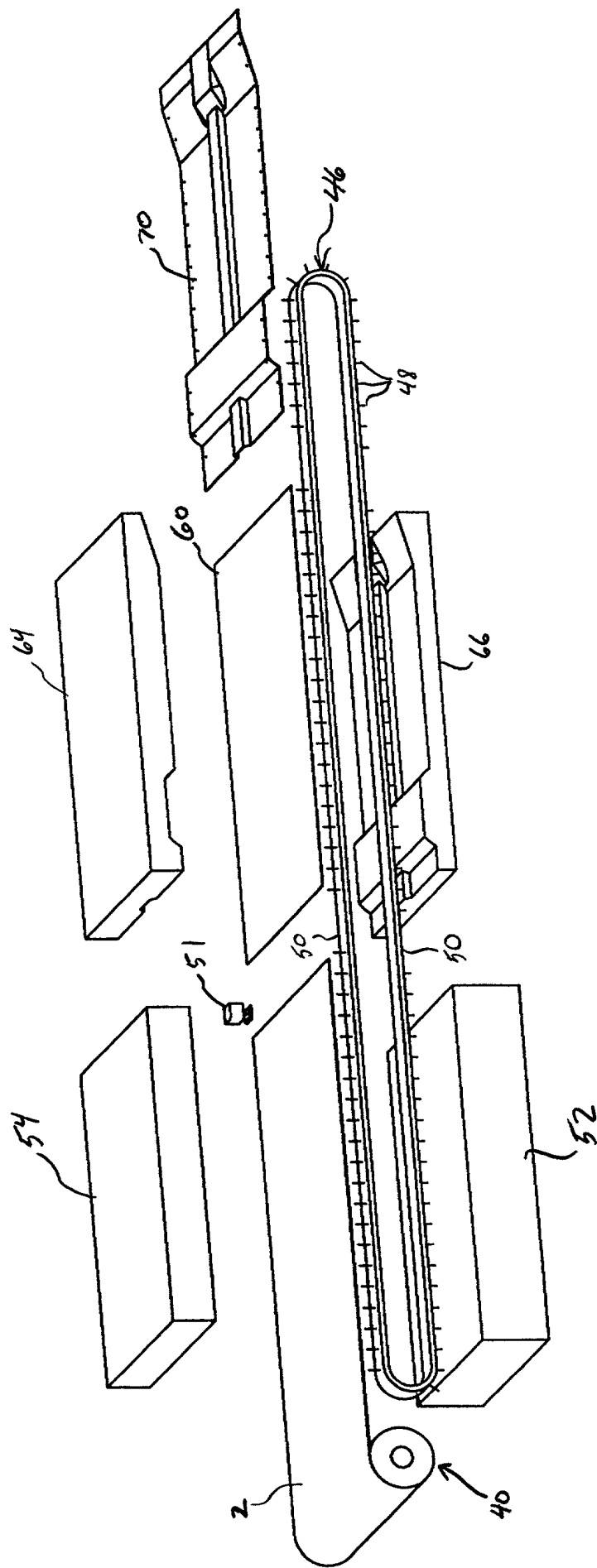


FIG. 6

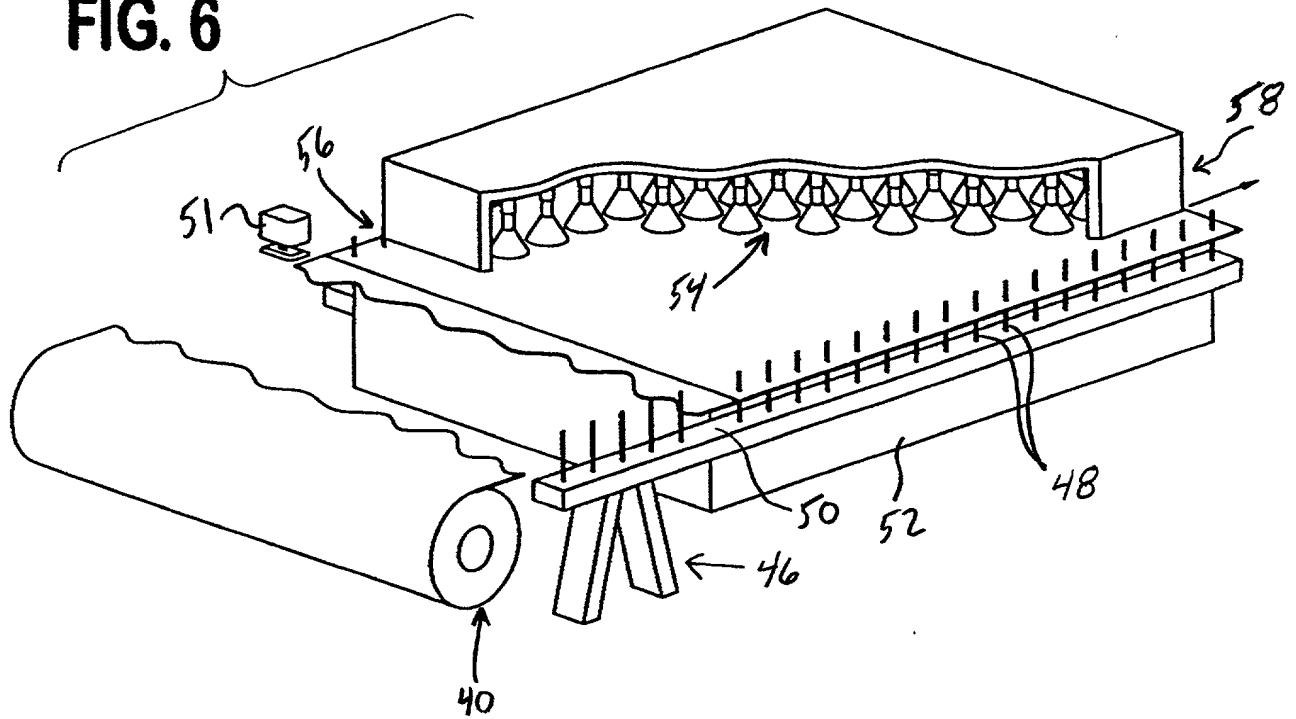


FIG. 7

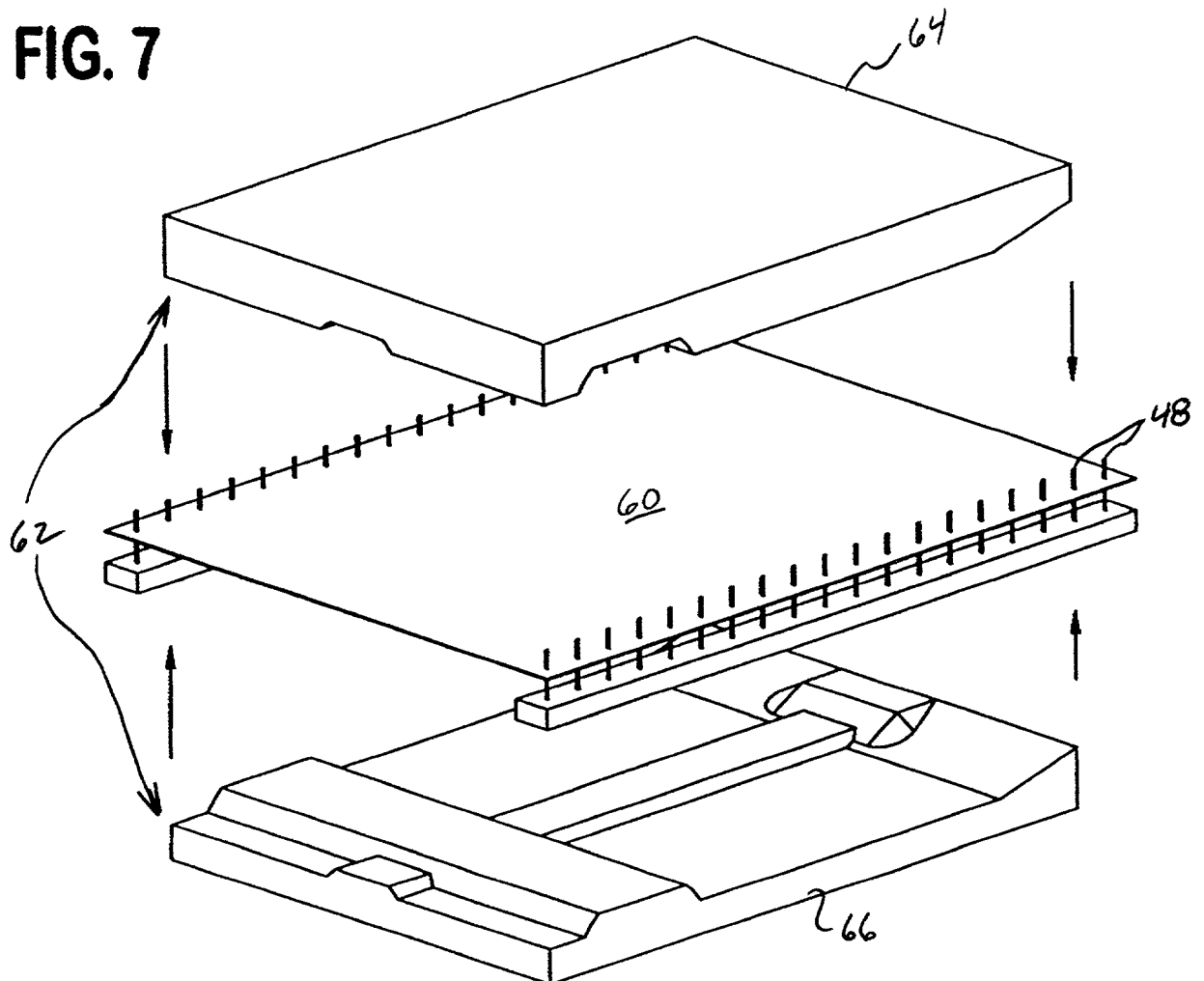


FIG. 8

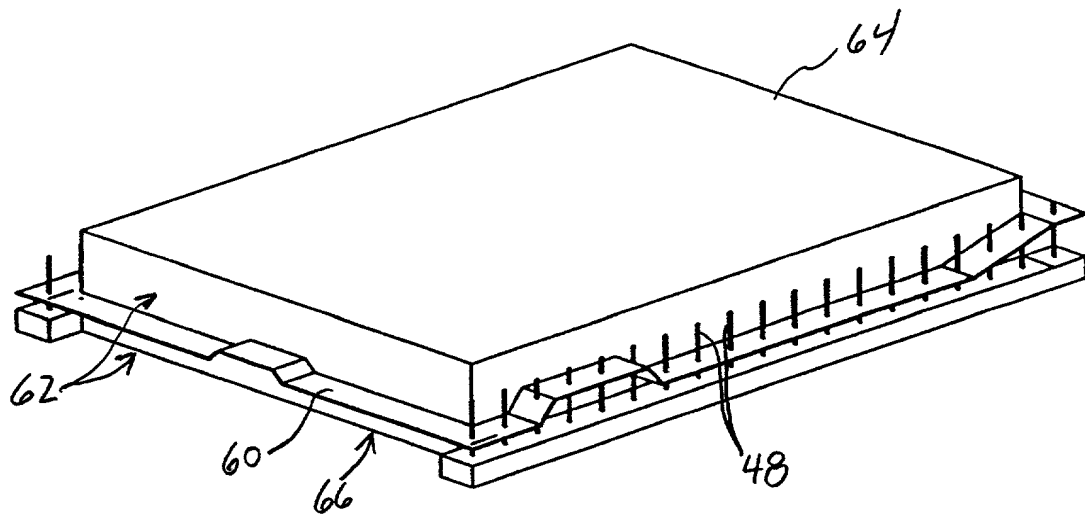
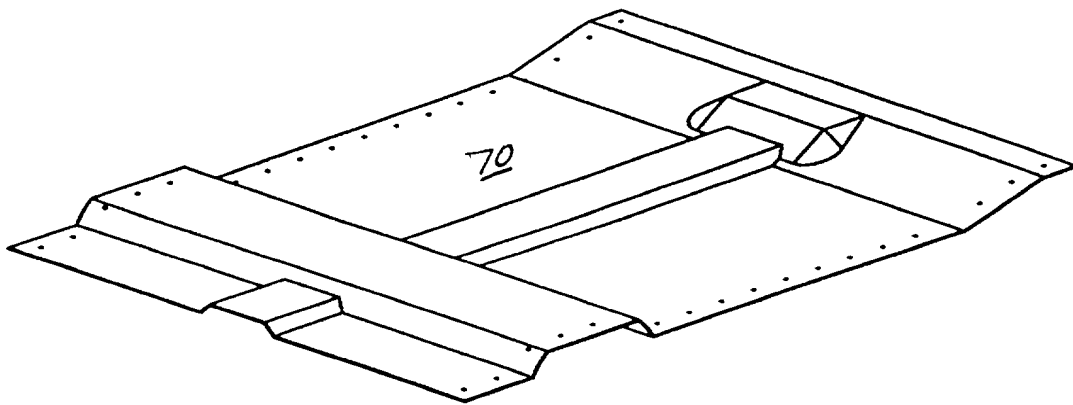


FIG. 9



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**DECLARATION FOR UTILITY OR
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(37 CFR 1.63)**☒ Declaration Submitted with Initial Filing **OR** ☐ Declaration Submitted after Initial Filing (surcharge (37 CFR 1.16 (e)) required)**Attorney Docket Number** MRA PT001**First Named Inventor** Burton J. Price**COMPLETE IF KNOWN****Application Number** NOT YET KNOWN**Filing Date** NOT YET KNOWN**Group Art Unit** NOT YET KNOWN**Examiner Name** NOT YET KNOWN**As a below named inventor, I hereby declare that:**

My residence, post office address, and citizenship are as stated below next to my name.

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled:

**METHOD FOR MANUFACTURING A SOUND INSULATING STRUCTURE AND
THE STRUCTURE PRODUCED THEREBY**the specification of which *(Title of the Invention)*☒ is attached hereto
OR☐ was filed on (MM/DD/YYYY) as United States Application Number or PCT InternationalApplication Number and was amended on (MM/DD/YYYY) (if applicable).

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment specifically referred to above.

I acknowledge the duty to disclose information which is material to patentability as defined in 37 CFR 1.56.

I hereby claim foreign priority benefits under 35 U.S.C. 119(a)-(d) or 365(b) of any foreign application(s) for patent or inventor's certificate, or 365(a) of any PCT international application which designated at least one country other than the United States of America, listed below and have also identified below, by checking the box, any foreign application for patent or inventor's certificate, or of any PCT international application having a filing date before that of the application on which priority is claimed.

Prior Foreign Application Number(s)	Country	Foreign Filing Date (MM/DD/YYYY)	Priority Not Claimed	Certified Copy Attached?	
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			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
			<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

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I hereby claim the benefit under 35 U.S.C. 119(e) of any United States provisional application(s) listed below.

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DECLARATION — Utility or Design Patent Application

I hereby claim the benefit under 35 U.S.C. 120 of any United States application(s), or 365(c) of any PCT international application designating the United States of America, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States or PCT International application in the manner provided by the first paragraph of 35 U.S.C. 112, I acknowledge the duty to disclose information which is material to patentability as defined in 37 CFR 1.56 which became available between the filing date of the prior application and the national or PCT international filing date of this application.

U.S. Parent Application or PCT Parent Number	Parent Filing Date (MM/DD/YYYY)	Parent Patent Number (if applicable)

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As a named inventor, I hereby appoint the following registered practitioner(s) to prosecute this application and to transact all business in the Patent and Trademark Office connected therewith:

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OR

☒ Registered practitioner(s) name/registration number listed below

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Anthony S. Volpe	28,377	Glenn M. Massina	40,081
C. Frederick Koenig III	29,662	Marilou E. Watson	42,213
Allan H. Fried	31,253	Jeffrey M. Glabicki	42,584
Gerald B. Halt, Jr.	37,633		

☐ Additional registered practitioner(s) named on supplemental Registered Practitioner Information sheet PTO/SB/02C attached hereto.

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Country	U.S.A.	Telephone	(215) 568-6400	Fax	(215) 568-6499

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Name of Sole or First Inventor:

☐ A petition has been filed for this unsigned inventor

Given Name (first and middle [if any])		Family Name or Surname			
Burton J.		Price			
Inventor's Signature				Date	
Residence: City	Bloomsburg	State	PA	Country	USA
Post Office Address	6 Blue Jay Drive				
Post Office Address					
City	Bloomsburg	State	PA	ZIP	17815
Country	USA				

☒ Additional inventors are being named on the 2 supplemental Additional Inventor(s) sheet(s) PTO/SB/02A attached hereto

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DECLARATION**ADDITIONAL INVENTOR(S)**
Supplemental Sheet
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Name of Additional Joint Inventor, if any:				<input type="checkbox"/> A petition has been filed for this unsigned inventor			
Given Name (first and middle [if any])				Family Name or Surname			
G. Michael				Whitaker			
Inventor's Signature						Date	
Residence: City	Bloomsburg	State	PA	Country	USA	Citizenship	USA
Post Office Address	10 W. 5th Street						
Post Office Address							
City	Bloomsburg	State	PA	ZIP	17815	Country	USA
Name of Additional Joint Inventor, if any:				<input type="checkbox"/> A petition has been filed for this unsigned inventor			
Given Name (first and middle [if any])				Family Name or Surname			
Kurt Alan				Kniss			
Inventor's Signature						Date	
Residence: City	Lewisburg	State	PA	Country	USA	Citizenship	USA
Post Office Address	728 1/2 Market Street						
Post Office Address							
City	Lewisburg	State	PA	ZIP	17837	Country	USA
Name of Additional Joint Inventor, if any:				<input type="checkbox"/> A petition has been filed for this unsigned inventor			
Given Name (first and middle [if any])				Family Name or Surname			
Inventor's Signature						Date	
Residence: City		State		Country		Citizenship	
Post Office Address							
Post Office Address							
City		State		ZIP		Country	

Burden Hour Statement: This form is estimated to take 0.4 hours to complete. Time will vary depending upon the needs of the individual case. Any comments on the amount of time you are required to complete this form should be sent to the Chief Information Officer, Patent and Trademark Office, Washington, DC 20231. DO NOT SEND FEES OR COMPLETED FORMS TO THIS ADDRESS. SEND TO: Assistant Commissioner for Patents, Washington, DC 20231.

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